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**Strader**

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(54) **SEALED SELF-ACTIVATING INJECTION DEVICE FOR DELIVERY OF MEDICINE FROM A PREFILLED CARTRIDGE OR VIAL**

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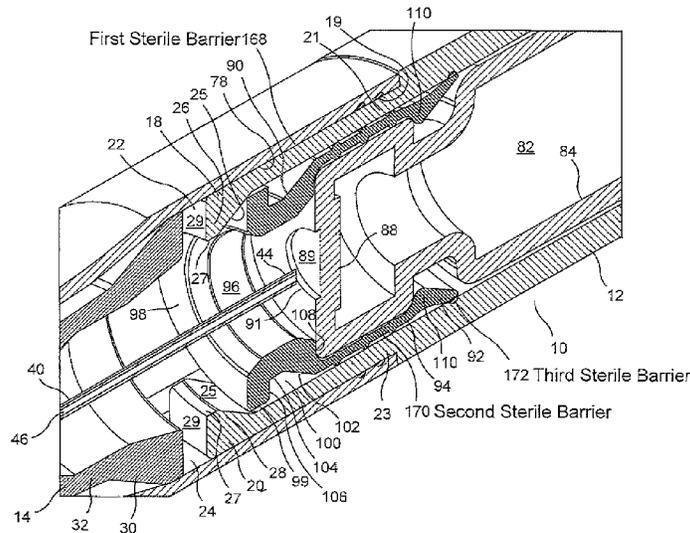
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(57) **ABSTRACT**

The disclosed embodiment relates to an injection device that is a single patient use, disposable device containing a needle and a cartridge containing a drug or pharmaceutical product. The device is initially provided in a pre-armed configuration wherein the needle sheath maintains cantilever locking tabs on the housing in a position to maintain the needle in a position separated from the septum of a cartridge. To arm the device, the practitioner removes the needle sheath and pushes down the plunger assembly. The cantilever locking tabs flex outwardly thereby allowing the cartridge-to-housing interface and the cartridge to move forward whereby the butt end of the needle punctures the septum of the cartridge. Additionally, the cantilever locking tabs form a stop configuration with the housing of the device. The disclosed embodiment is particularly adaptable to dental anesthetic applications, as well as other medical and veterinary applications.

**31 Claims, 19 Drawing Sheets**



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See application file for complete search history.

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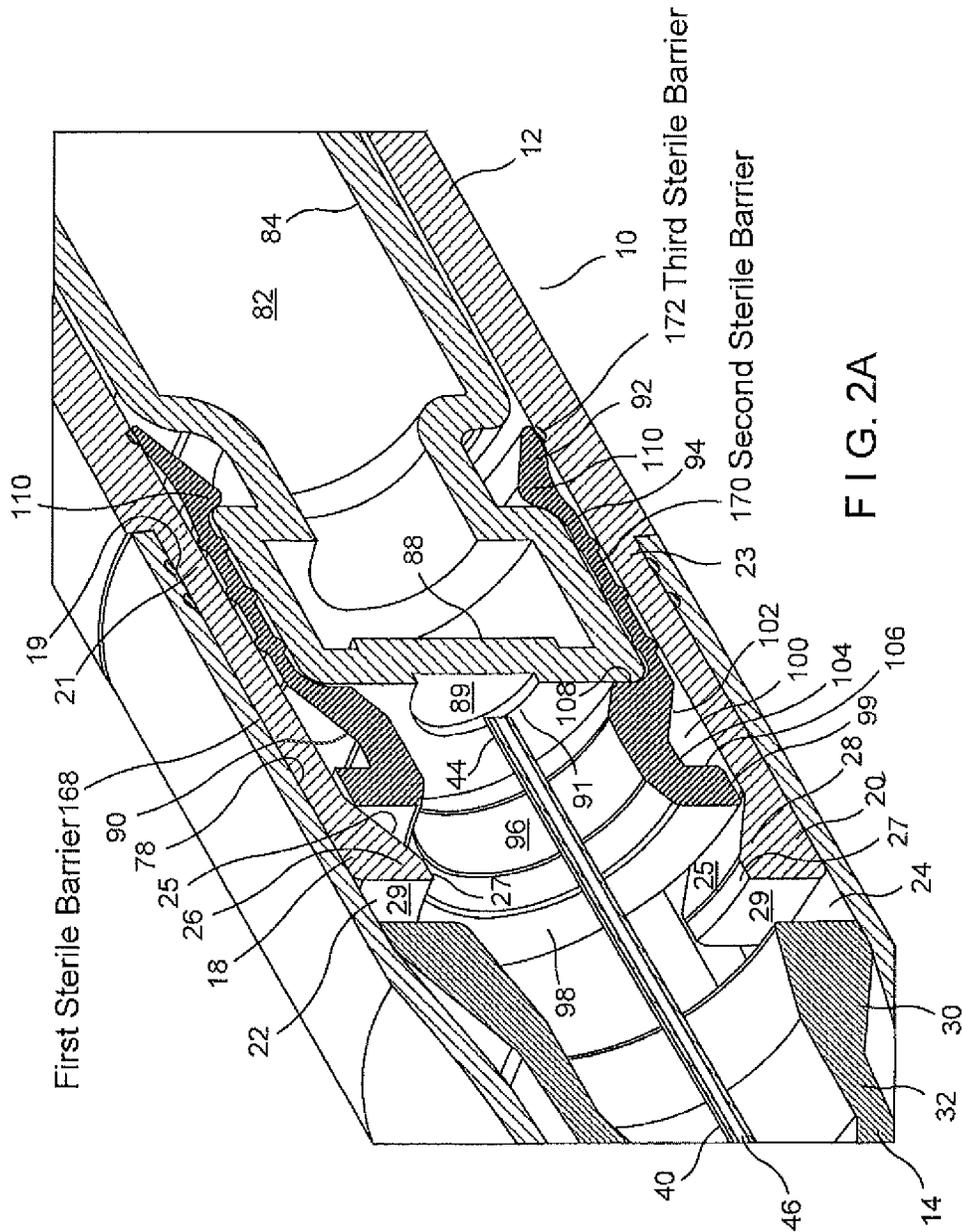
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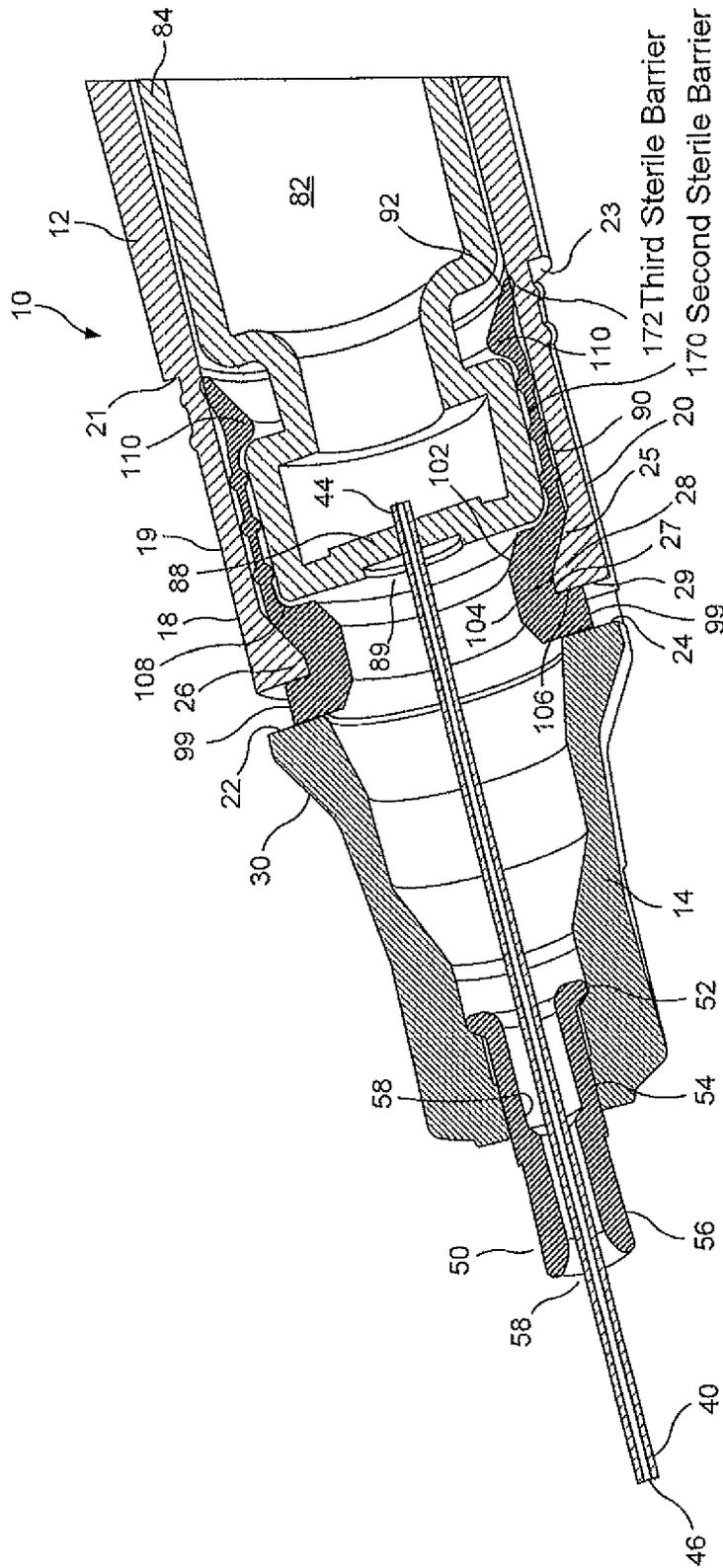


FIG. 2B

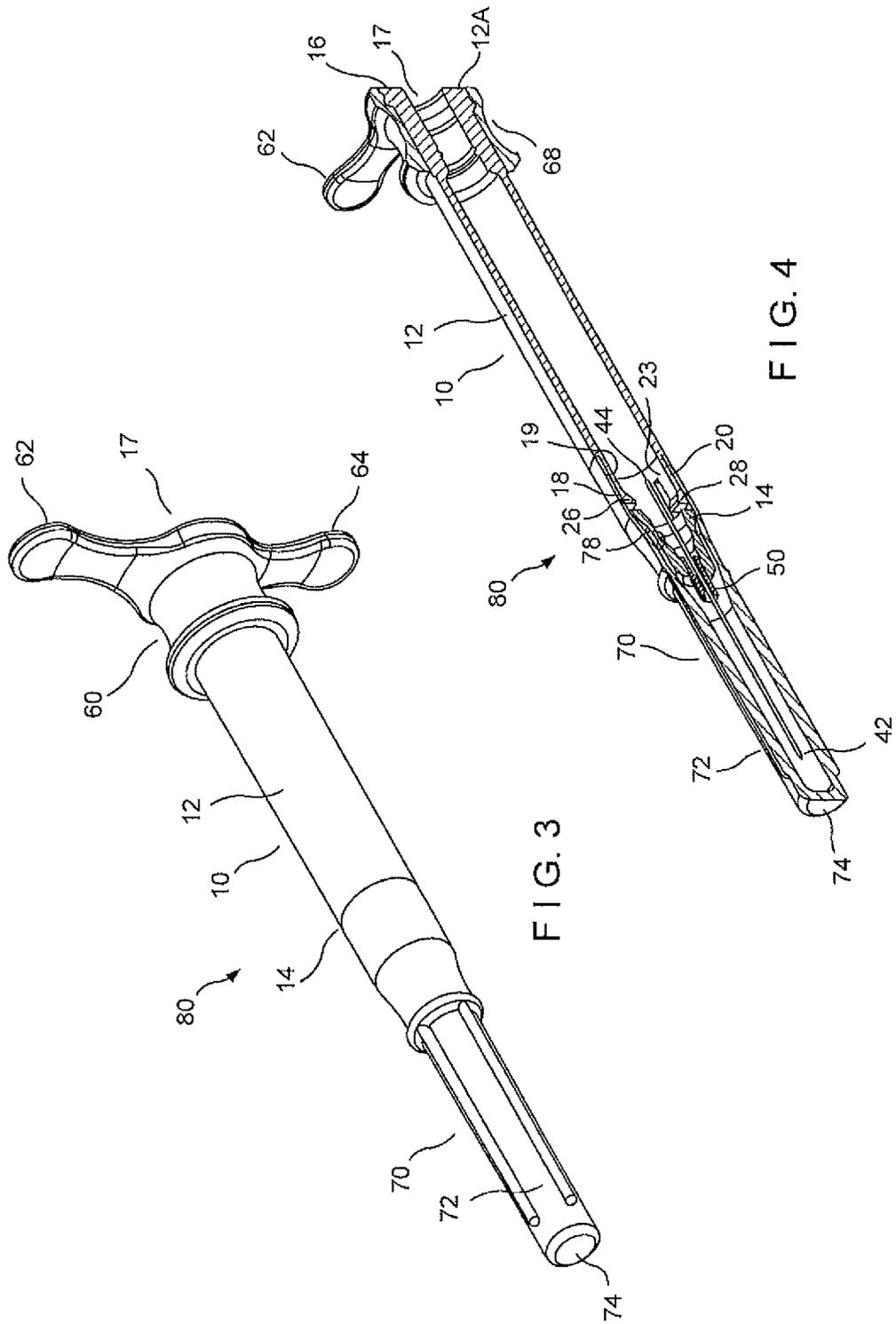
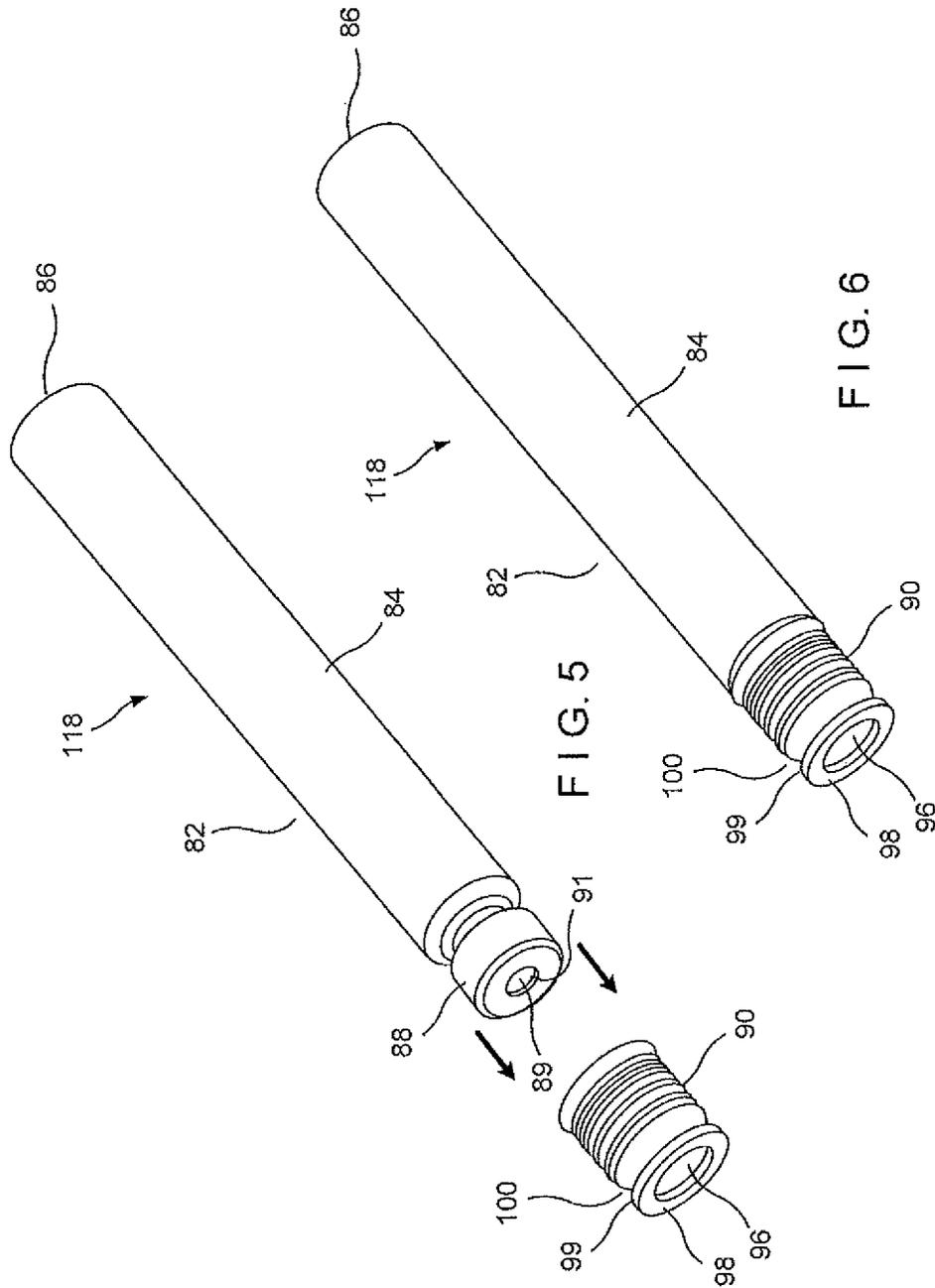
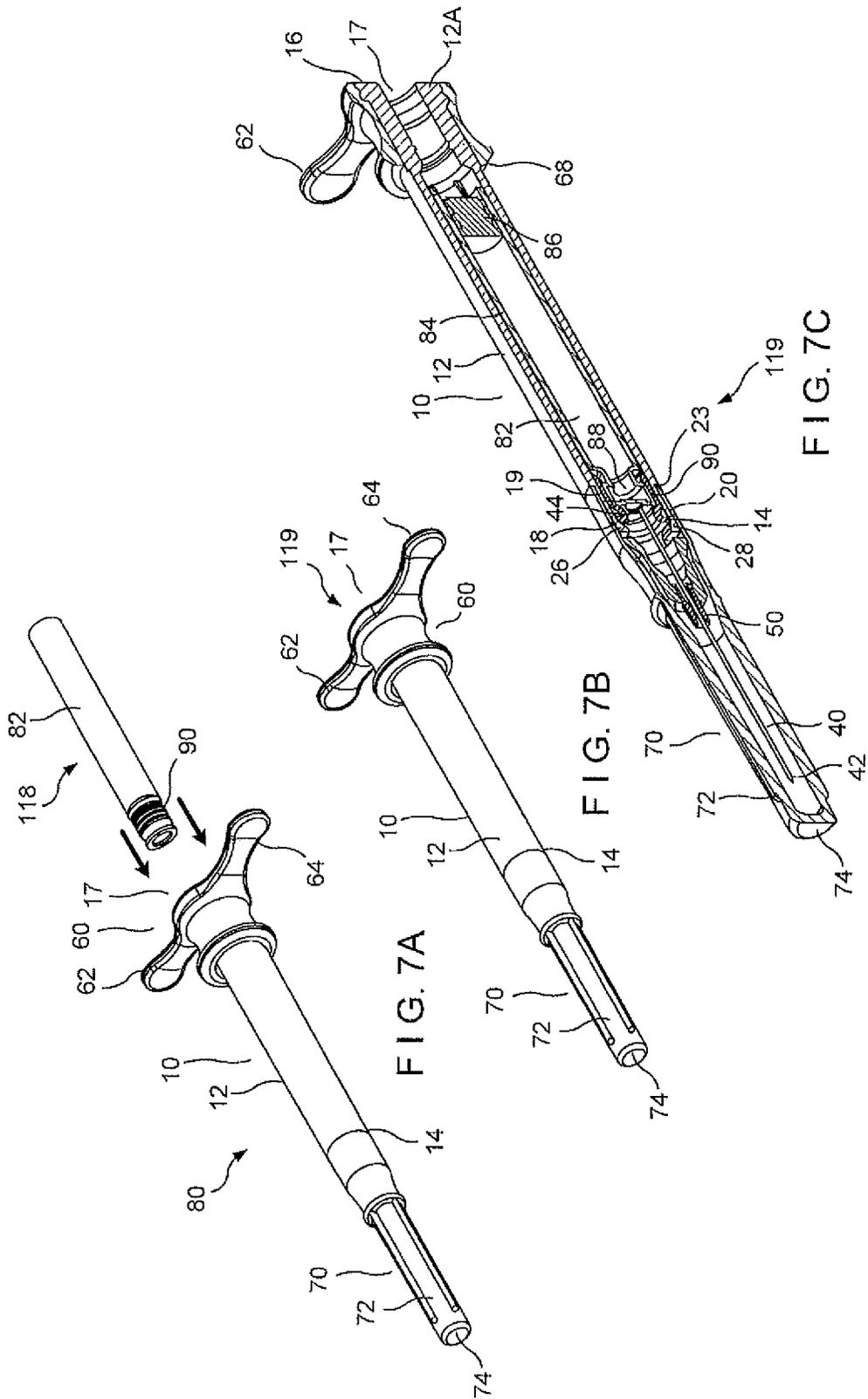


FIG. 3

FIG. 4





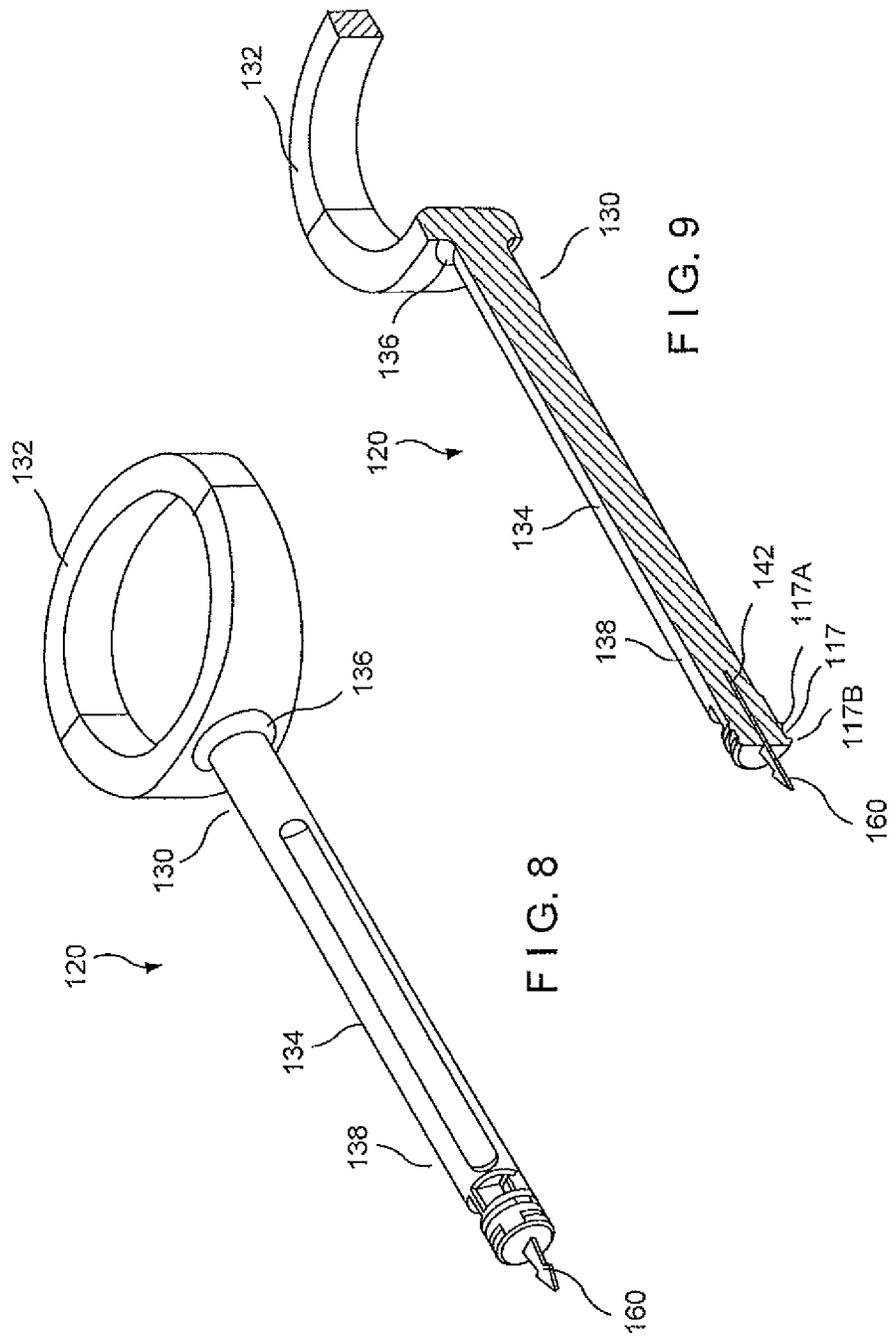
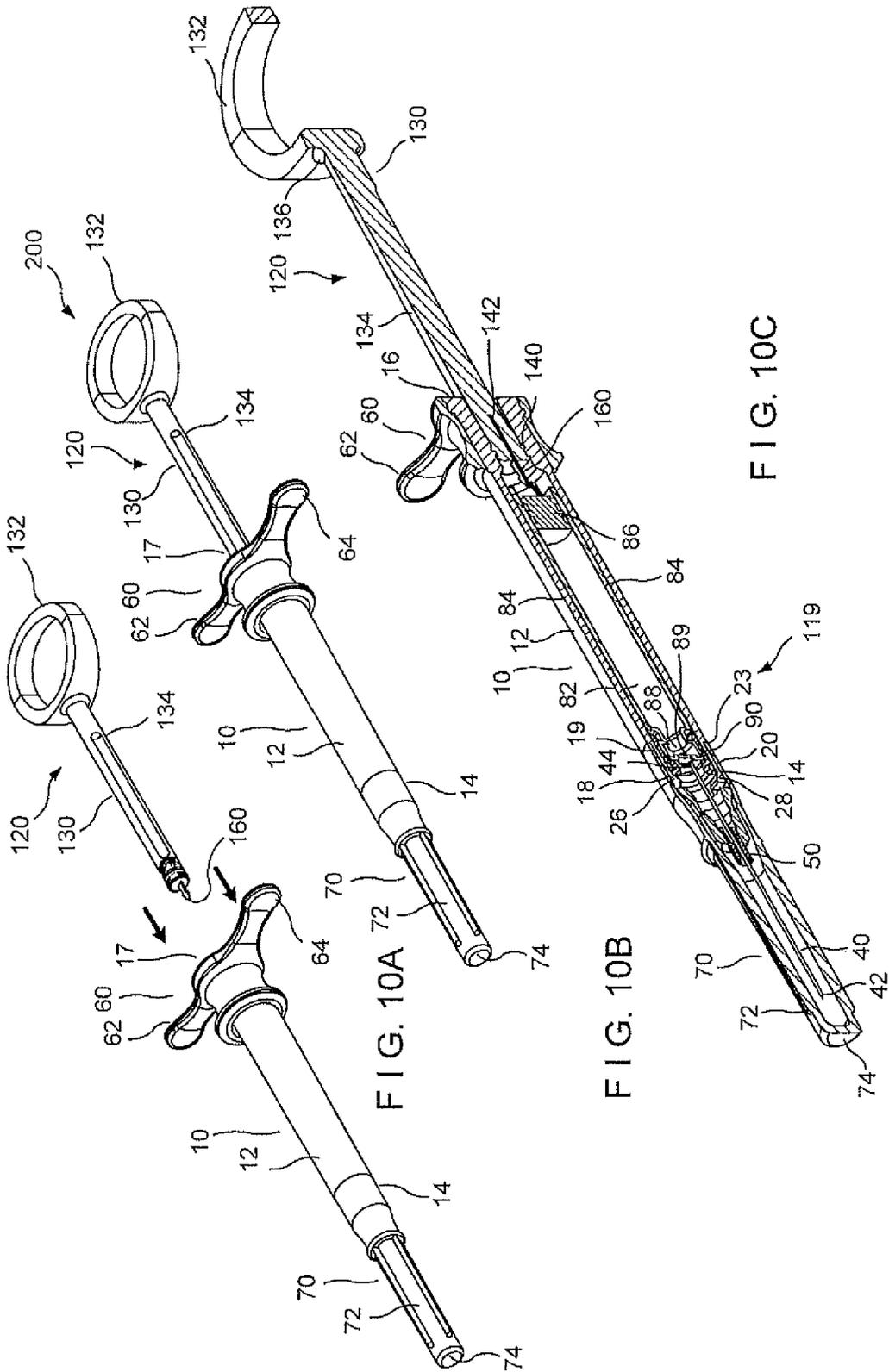


FIG. 8

FIG. 9







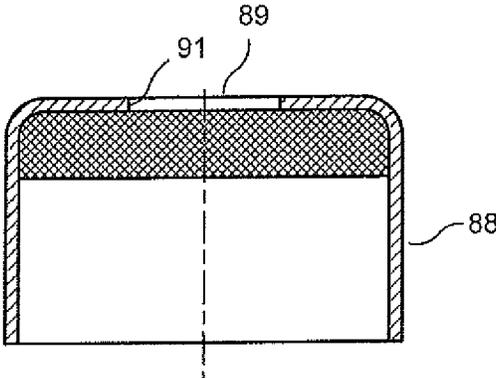


FIG. 13A

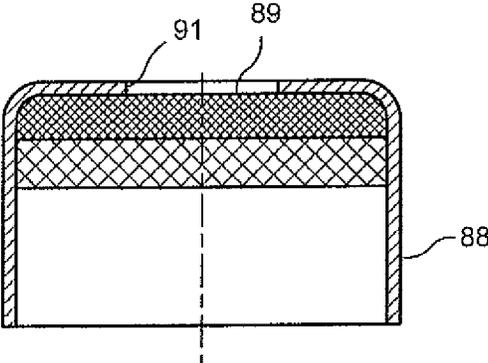


FIG. 13B

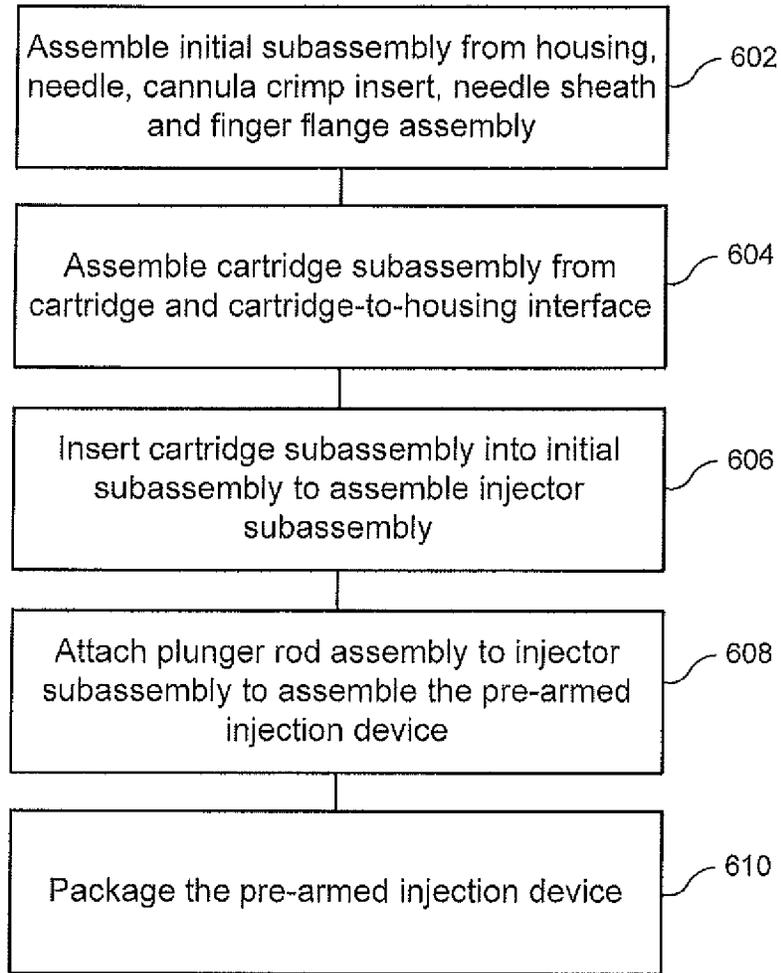
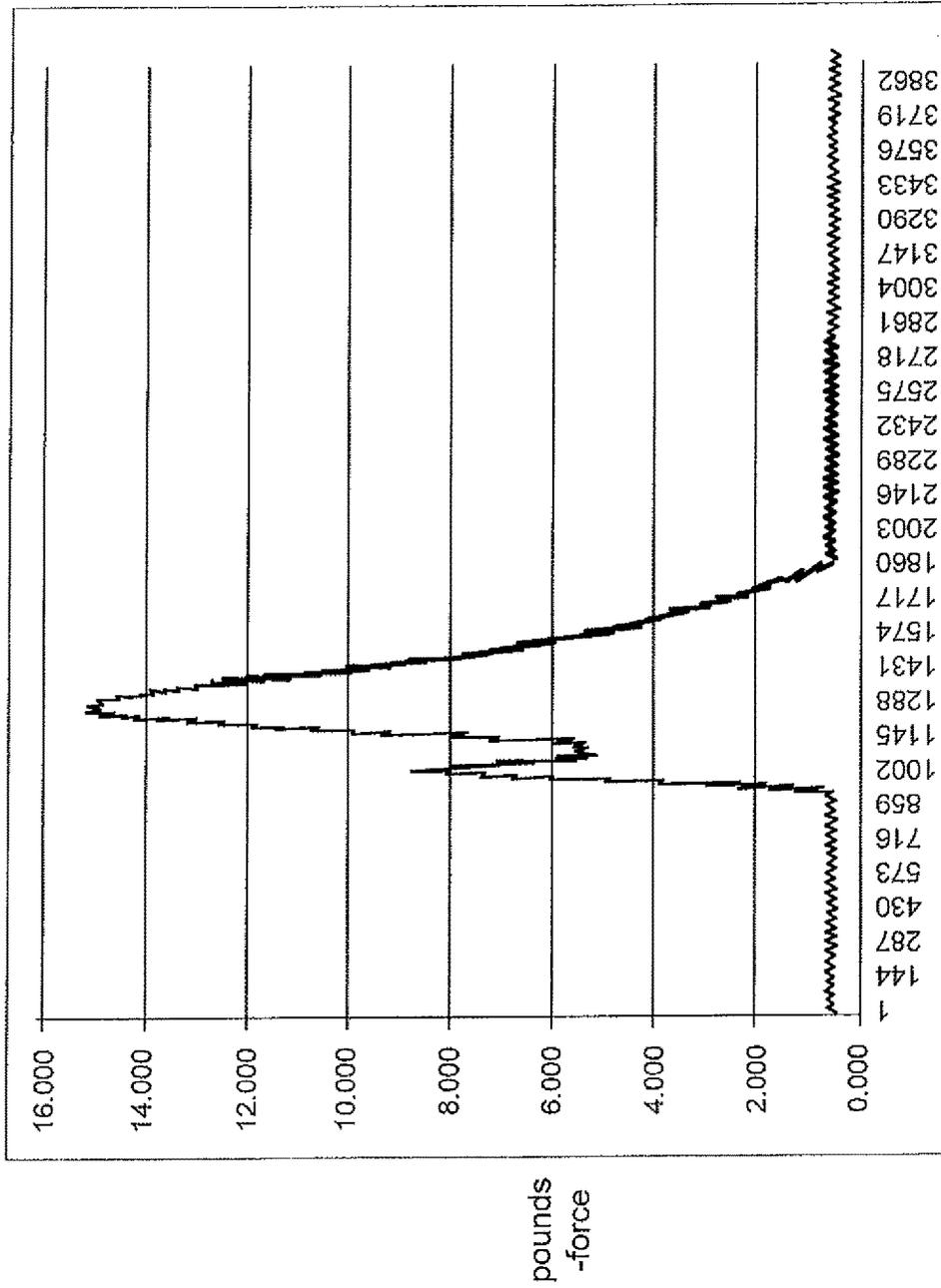


FIG. 14



1/24000ths of a second

FIG. 15

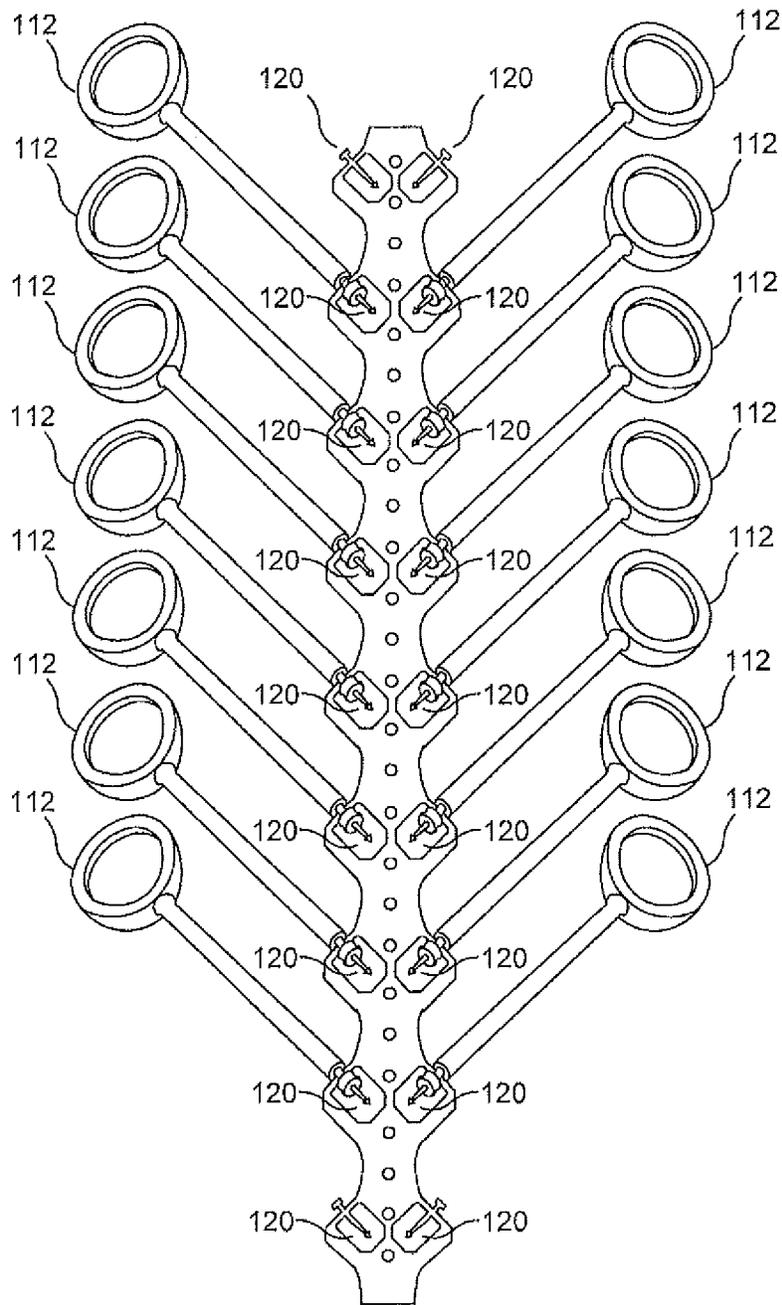


FIG. 16

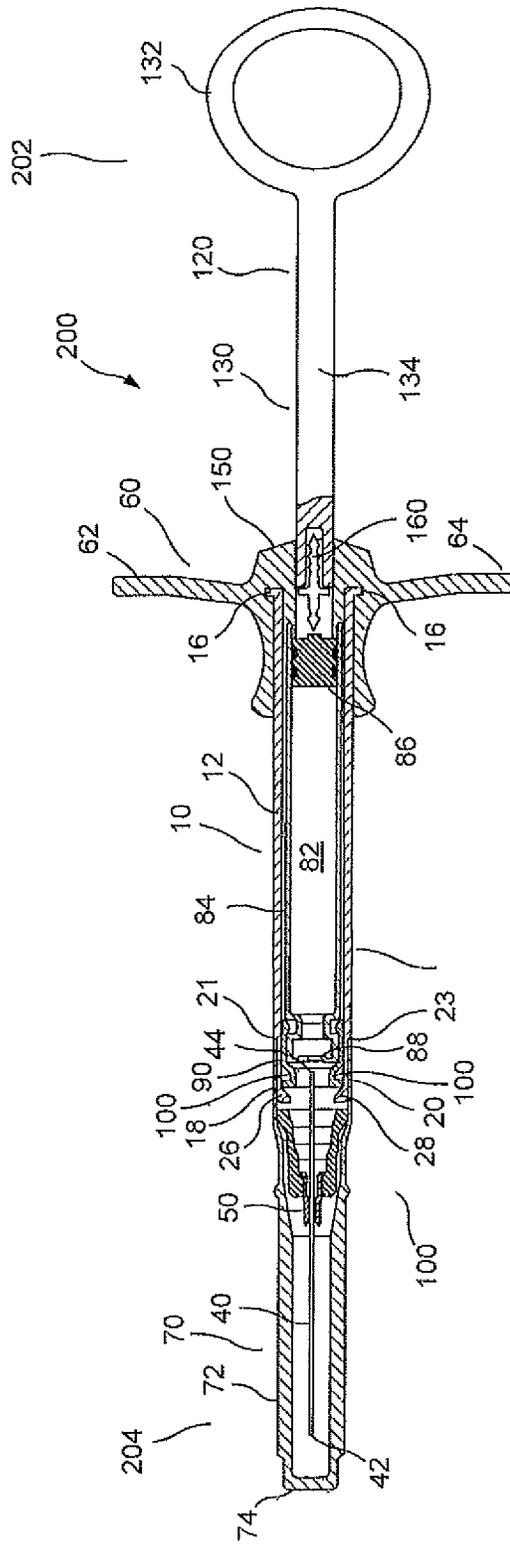


FIG. 17

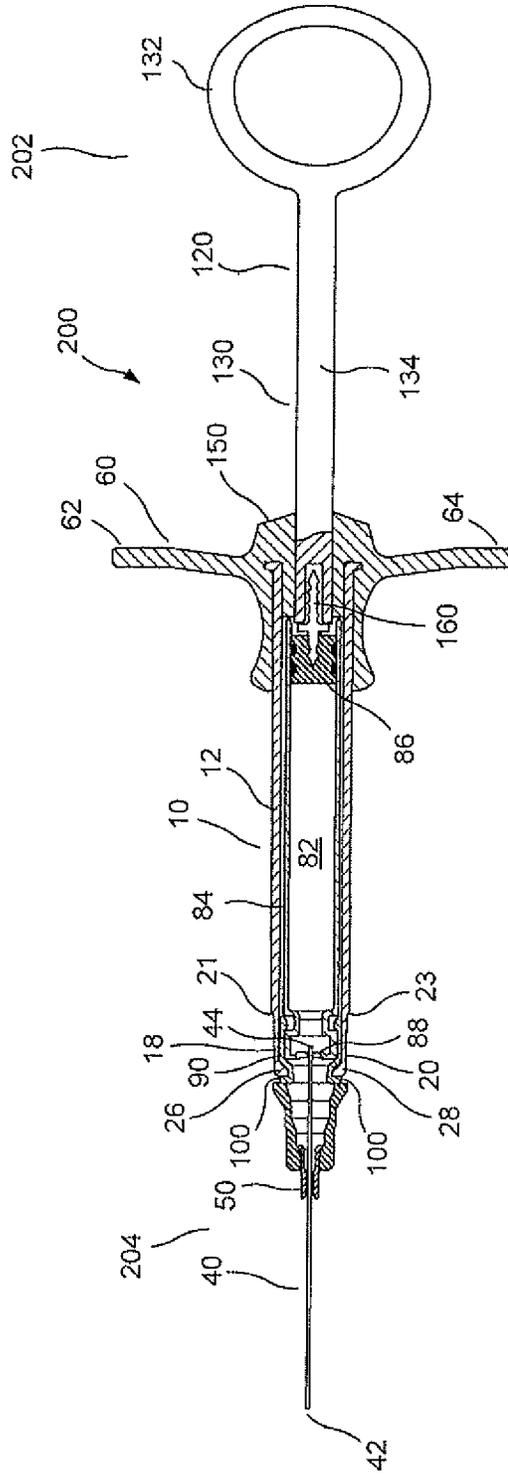


FIG. 18

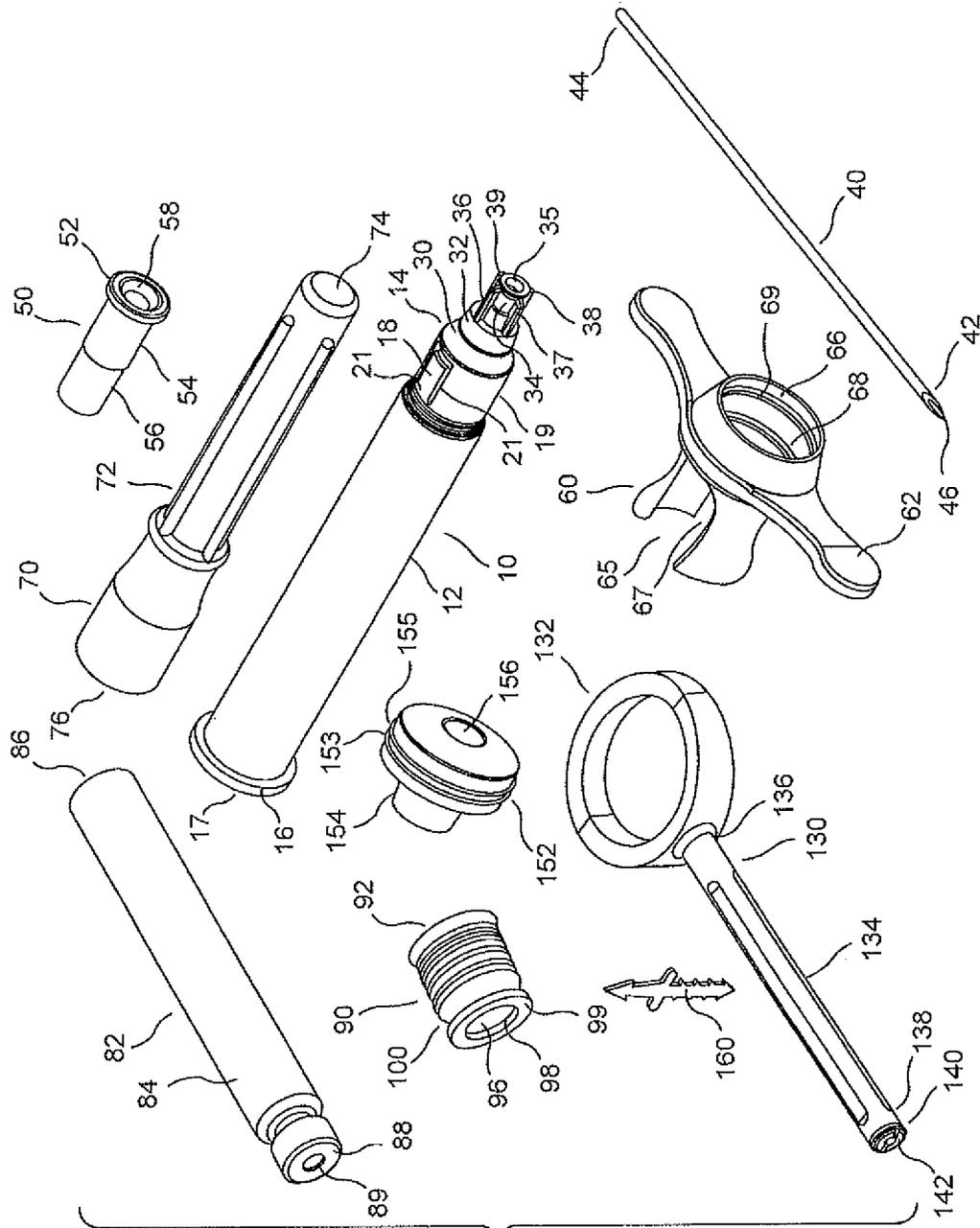


FIG. 19

**SEALED SELF-ACTIVATING INJECTION  
DEVICE FOR DELIVERY OF MEDICINE  
FROM A PREFILLED CARTRIDGE OR VIAL**

This application claims priority under 35 U.S.C. 119(e) of U.S. Provisional Patent Application Ser. No. 61/875,274, filed on Sep. 9, 2013, the disclosure of which is incorporated by reference herein in its entirety.

BACKGROUND

The present disclosure relates to a syringe or similar injection device, which is configured to inject an injectable agent from a pre-loaded cartridge, in a single-use configuration.

Conventionally, syringes for the sterile injection of injectable agents in the medical, dental or veterinary fields are filled with the injectable agent by a medical professional just prior to use. However, conventional prior art syringes may be problematic in that they may place the medical professional at a higher risk for an accidental needle stick due to the handling before and after the injection.

SUMMARY

It is therefore an object of the present disclosure to provide improvements in syringe-type injection devices, particularly pre-loaded single-use, disposable devices containing a needle and a cartridge containing an injectable agent, wherein the injection device has an armed and a pre-armed state.

It is therefore a further object of the present disclosure to provide improvements in syringe-type injection devices which are particularly adaptable to sterile injection of injectable agents, wherein the injection device has an armed and a pre-armed state.

These and other objects are attained by providing a sterile injector assembly, pre-loaded with an injectable agent. The sterile needle assembly includes a stainless steel cannula set within a hub with a needle sheath, bulk packaged and sterilized by gamma ray or ultra-violet irradiation or a similar process as appropriate to the design.

More particularly, taught herein is a disposable and sterile pre-loaded injection device comprising a cartridge with a closed first cartridge end and a second cartridge end including a cartridge plunger, a housing enclosing the cartridge, the housing including cantilevered locking tabs, a needle, an adapter engaging the first cartridge end and further including an adapter engagement element, wherein the adapter is movable with respect to the cantilevered locking tabs, between a pre-armed position wherein the needle is separated from the cartridge and an armed position wherein the needle penetrates the septum of the cartridge.

Additionally, taught herein is a method of manufacture of an injection device including the steps of engaging a sterile cartridge to a sterile adapter, loading the sterile cartridge with the sterile adapter into a housing, and securing the sterile cartridge with the sterile adapter within the housing.

In order to use the device, the medical professional (which may include a dental, veterinary or similar professional) removes the device from the packaging, engages the plunger rod in some embodiments, removes the needle sheath (thereby removing the constraints on the outward flexure of the cantilevered locking tabs) and depresses the plunger rod. Movement of the plunger rod causes the cartridge assembly to move forward relative to a fixed or stationary housing thereby flexing the cantilevered locking tabs outwardly and

advancing the septum into the butt end of the cannula thereby reaching the armed or detent position, creating a sterile fluid path for the injectable agent and allowing the injectable agent of the cartridge to be dispensed. In this armed or detent position, the cartridge assembly is locked in place by the cantilevered locking tabs and cannot be detached or retracted during aspiration.

BRIEF DESCRIPTION OF THE DRAWINGS

Further objects and advantages of the disclosure will become apparent from the following description and from the accompanying drawings, wherein:

FIG. 1A is a cross-sectional view of the assembled injection device of the present disclosure in the pre-armed configuration, including cross-sectional areas of detail along plane A-A and plane B-B.

FIG. 1B is a cross-sectional view of the assembled injection device of the present disclosure in the armed configuration.

FIG. 1C is a perspective view of the various disassembled elements of the injection device of the present disclosure.

FIG. 2A is a perspective cut-away view in detail, showing the cartridge-to-housing interface and its relation to the surrounding components in the pre-armed configuration of the injection device of the present disclosure.

FIG. 2B is a perspective cut-away view in detail, showing the cartridge-to-housing interface and its relation to the surrounding components in the armed configuration of the injection device of the present disclosure.

FIG. 3 is a perspective view of a partially assembled injection device of the present disclosure, prior to the insertion of the cartridge and plunger assembly.

FIG. 4 is a partially cut-away view corresponding to FIG. 2.

FIG. 5 is a perspective partially exploded view illustrating the attachment of the cartridge-to-housing interface to the cartridge of the present disclosure.

FIG. 6 is a perspective view of the assembly of the cartridge-to-housing interface and the cartridge of the present disclosure.

FIG. 7A illustrates the insertion of the assembled cartridge-to-housing interface and cartridge of FIGS. 5 and 6 into the partially assembled injection device of FIG. 3, of the present disclosure.

FIG. 7B is a perspective view of the partially assembled injection device of the present disclosure, containing the cartridge-to-housing interface and cartridge of FIGS. 5 and 6.

FIG. 7C is a perspective cut-away view corresponding to FIG. 7B.

FIG. 8 is a perspective view of the plunger assembly of the present disclosure.

FIG. 9 is a perspective cut-away view of the plunger assembly of the present disclosure.

FIG. 10A illustrates the insertion of the plunger rod assembly of FIGS. 7 and 8 into the partially assembled injection device of FIGS. 9A, 9B and 9C of the present disclosure.

FIG. 10B is a perspective view of the fully assembled injection device of the present disclosure in the pre-armed configuration.

FIG. 10C is a perspective cut-away view corresponding to FIG. 10B.

FIG. 11A is a further perspective cut-away view, showing the cartridge-to-housing interface and its relation to the

surrounding components in the pre-armed configuration of the injection device of the present disclosure.

FIG. 11B is a perspective view of the needle sheath and surrounding components of the injection device of the present disclosure, the needle sheath constraining the injection device to the pre-armed configuration.

FIG. 12A is a perspective cut-away view, showing the cartridge-to-housing interface and its relation to the surrounding components in the armed or detent configuration of the injection device of the present disclosure, with the septum of the cartridge punctured.

FIG. 12B is a perspective view corresponding to FIG. 12A.

FIGS. 13A and 13B are cross-sectional views of the cap and septum of the present disclosure.

FIG. 14 is a flowchart of the assembly of the injection device of the present disclosure.

FIG. 15 is a chart of force versus time for a thumb ring and plunger of an embodiment of the present disclosure.

FIG. 16 is a diagram of a plunger assembly strip which may be used in the assembly of an embodiment of the present disclosure.

FIG. 17 is a cross-sectional view of an alternative embodiment of the assembled injection device of the present disclosure in the pre-armed configuration.

FIG. 18 is a cross-sectional view of an alternative embodiment of the assembled injection device of the present disclosure in the armed configuration.

FIG. 19 is an exploded view of the components of the alternative embodiment of the injection device of FIGS. 17 and 18.

#### DETAILED DESCRIPTION

Disclosed herein are pre-loaded syringe assemblies with a plurality of sterility barriers and aseptic methods of manufacturing the same. The pre-loaded syringe assemblies include a plurality of sterility barriers to maintain the sterility of certain components of the syringe assemblies during packaging, shipping and storage until use by a medical professional. The pre-loaded syringe assemblies taught herein are shipped to a medical professional in a pre-armed state while maintaining sterility of the contents of a pre-loaded cartridge and the surfaces of components that will come into contact with the contents of the cartridge. Prior to use of the pre-loaded syringe assemblies taught herein a medical professional places the assembly in an armed state by forming a sterile fluid pathway between a needle tip and the contents of the cartridge. Placement of the assembly into the armed state occurs by placing pressure on a terminal end of a plunger to move the cartridge toward a distal end of the assembly and cause a butt end of the needle to pierce a septum attached to the cartridge. During arming, the cartridge and the plunger move distally relative to a fixed housing.

Referring now to the drawings in detail wherein like numerals indicate like elements throughout the several views, one sees that the injection device 200 is a single-patient, single-use, disposable, sterile injection device pre-loaded with an injectable agent. As used herein, the term "injectable agent" refers to, but is not limited to, local anesthetics, therapeutic or pharmaceutical agents, cosmetic agents or other liquids, gels or powders in the medical, dental, veterinary or cosmetic fields. Further, one sees that FIG. 1A is a cross-sectional view of the fully assembled injection device 200, with a proximal end 202 and a distal end 204, in a pre-armed state (i.e., a sterility barrier of the

cartridge 82 has not been pierced by the butt end 44 of the needle cannula 40 prior to the formation of a continuous sterile pathway from the cartridge 82 to the tip 42 of needle cannula 40 to inject the injectable agent), with a cartridge 82 concentrically surrounded by housing 10. The cartridge 82 includes a cartridge plunger 86 on one end and a cap or band 88 on the other end that secures a septum 89 thereto. The septum 89 forms one sterility barrier to maintain sterility of a liquid held in the cartridge 82. A cartridge-to-housing interface 90 engages the cap 88 of the cartridge 82. The housing 10 includes first and second cantilevered locking tabs 18, 20 which are constrained from outward flexure by the outward concentric engagement of the needle sheath 70. The cantilevered first and second locking tabs 18, 20, in this constrained position, prevent the forward movement of the cartridge-to-housing interface 90 and the cartridge 82 thereby maintaining a separation between the butt end 44 of the cannula 40 and the septum 89 of cartridge 82 held in place by cap or band 88. Often, the harpoon 160 is visible through the housing, allowing the medical professional visualization of the harpoon 160. Moreover, the length of housing 10 which provides for the visibility of the harpoon 160 further often provides for improved axial control of the injection device 200 during operation.

In the armed state (i.e., piercing of the sterility barrier by the butt end 44 of the needle cannula 40 to form a continuous sterile pathway from the cartridge 82 to the tip 42 of cannula 40 to inject the injectable agent) of injection device 200, which is illustrated in FIG. 1B, the needle sheath 70 has been removed thereby allowing outward flexure of the first and second locking tabs 18, 20 and further allowing the cartridge 82 and cartridge-to-housing interface 90 to be moved forward toward the distal end 204 by motion on the plunger rod 130 so that the butt end 44 of the cannula 40 penetrates the septum 89 of the cartridge 82. As the cartridge 82 and cartridge-to-housing interface 90 are moved forward relative to the fixed housing 10, first and second latching bosses 26, 28 engage the annular notch 100 of the cartridge-to-housing interface 90. In this armed state, the injection device 200 is ready for use by a medical professional. It should be noted that while the first and second latching bosses 26, 28 are illustrated as being inwardly extending, that it is envisioned that this disclosure, particularly regarding latching and engagement elements, could encompass many different equivalent structures, for example, detents, stops, latches, catches and the like.

FIG. 1C illustrates the various components for the assembly of injection device 200. The housing 10, which can be seen in further detail in cut-away in FIGS. 1A (including areas of cross-sectional detail A-A and B-B), 1B, 2A, 2B, 4, 7C, 10C, 11A, and 12A, is made from hard polyethylene or polypropylene, but is not limited thereto, and includes a cylindrical body 12 with a forward nose 14 and a mounting hub 12A of somewhat increased diameter on its proximal end. A passageway 63 of reduced diameter passing there-through for receiving the plunger rod assembly 120 as shown in FIGS. 8 and 9. Mounting hub 12A further includes radially oriented internal fins 69A between the interior wall of mounting hub 12A and the exterior wall of passageway 63 (see cross-sectional area of detail B-B of FIG. 1A). Mounting hub 12A further includes an annular lip 16 with an annular groove 16A formed thereon for mounting or rotatably engaging the finger flange assembly 60 (see the area of cross-sectional detail A-A of FIG. 1A as well as FIGS. 7A-7C). The finger flange assembly is often rotatably mounted, but other embodiments include a finger flange assembly which is fixed.

The forward nose **14** of cylindrical body **12** includes a section **19** of reduced diameter which further includes the first and second cantilevered locking tabs **18, 20**. As shown in FIG. 2A, the first and second cantilevered locking tabs **18, 20** are formed from and integral with the wall of section **19** of reduced diameter and defined by first and second channels **22, 24** cut on three sides of the first and second cantilevered locking tabs **18, 20** thereby forming respective first and second cantilevered integral connections **21, 23** with the section **19** of reduced diameter. Additionally, as shown in detail in FIGS. 2A and 2B, the interior forward end of first and second cantilevered locking tabs **18, 20** include first and second latching bosses **26, 28**. As shown in the cut-away views of FIGS. 2A and 2B, the first and second latching bosses **26, 28** each include a ramped portion **25**, a flat distal portion **27** and a transverse orthogonal wall **29**. The forward nose **14** further includes a frustoconical section **30** leading to first cylindrical portion **32** which, in turn, leads to cylindrical wall **34** forming cannula passageway **35**. Four support wall segments **36, 37, 38, 39** radially extend from cylindrical wall **34**.

Needle cannula **40** is of conventional structure, made from stainless steel or a similar material, but not limited thereto, with a beveled pointed forward end **42** for insertion into a patient or other injection point, a rear or butt end **44** for receiving an injectable agent, and a central passageway **46**.

Cannula crimp insert **50**, made from stainless steel or a similar material, but not limited thereto, includes a rearward rimmed base **52** along with first and second cylindrical portions **54, 56**, wherein first cylindrical portion **54** has a slightly greater diameter than second cylindrical portion **56** in order to seat within the interior of nose **14** of housing **10**. Cannula crimp insert **50** further includes central passageway **58** for receiving and engaging needle cannula **40**.

Finger flange assembly **60** is formed from injection molded plastic, but is not limited thereto, and may have no sterility requirement. Finger flange assembly **60** has two finger flanges **62, 64** for use by the medical practitioner during injection and further has a central bore **66** with an internal annular ridge **68** for engaging annular groove **16A** of annular lip **16** of mounting hub **12A** of housing **12** thereby providing for a snap fit with rotatable engagement between the finger flange assembly **120** and the mounting hub **12A** which allows the user or medical practitioner to orient the bevel **42** of the needle cannula **40** during use. Bevel orientation can be achieved in other ways, such as, but not limited to, a fixed finger flange assembly in combination with either a rotating plunger rod or a plunger rod with a rotating harpoon.

Needle sheath **70** includes a generally cylindrical wall **72** with a closed end **74** and an open end **76**. The sheath **70** is formed from polyethylene or polypropylene, but is not limited thereto. The interior of cylindrical wall **72** immediately inwardly adjacent from open end **76** includes an internal contour **78** to outwardly concentrically engage the following portions of housing **10**, section **19** of reduced diameter, frustoconical section **30**, first cylindrical portion **32** and wall segments **36, 37, 38, 39**. While the needle sheath **70** is mounted on housing **10** thereby forming first sterile barrier **168** extending circumferentially around the outer diameter of section **19** of reduced diameter as it contacts the inner diameter of sheath **70** as shown in FIG. 2A, the concentric engagement of internal contour **78** of needle sheath **70** to section **19** of reduced diameter of housing **10** prevents the outward flexure of the first and second cantilevered locking tabs **18, 20** of the housing **10**.

FIGS. 3 and 4 illustrate the axial relationship and configuration of housing **10**, needle cannula **40**, cannula crimp insert **50**, finger flange assembly **60** and needle sheath **70** in order to achieve initial subassembly **80**. The needle cannula **40** is inserted into cannula crimp insert **50**. Thereafter, the cannula crimp insert **50**, with the needle cannula **40** therein, is inserted through the rear opening **17** of housing **10** and inserted so as to be engaged within cannula passageway **35** within the forward nose **14** of housing **10**. Alternatively, the needle cannula **40** may be directly secured to the housing **10** by an adhesive bond or a similar method thereby eliminating the cannula crimp insert **50**. The needle sheath **70** is mounted on housing **10** so as to outwardly concentrically engage section **19** of reduced diameter, frustoconical section **30**, first cylindrical portion **32** and wall segments **36, 37, 38, 39** of housing **10**. Finger flange assembly **60** is mounted on housing **10** by engaging annular ridge of **68** of finger flange assembly **60** to annular groove **16A** of annular lip **16** of mounting hub **12A**. The initial subassembly **80** of FIGS. 3 and 4 is bulk sterilized either before or after assembly, by ultra-violet, gamma ray or a similar method as appropriate to the design.

FIGS. 5 and 6, as well as FIG. 1C, illustrate the axial relationship and configuration of the cartridge **82** and the cartridge-to-housing interface **90**. As shown in the cut-away view of FIG. 7C, the cartridge **82** includes cylindrical glass wall **84**, containing the injectable agent therein, and further includes a cartridge plunger **86** at one end and an aluminum cap or band **88** at the other end, holding a septum **89** in place.

The cartridge-to-housing interface **90** is formed from hard polyethylene or polypropylene, but is not limited thereto, and includes a first end **92** with cylindrical wall **94** for forming a tight fit around the cap **88** of cartridge **82**, holding septum **89** in place. As shown in FIGS. 13A and 13B, the cap **88** holds the septum **89** in place (FIG. 13A discloses a single layer septum **89** while FIG. 13B discloses a dual layer septum **89**), exposed through opening **91** in cap **88**. The combination of the cap **88** and the septum **89** form a piercable sterility barrier to maintain sterility of the contents of the pre-loaded cartridge **82**. Cartridge-to-housing interface **90** further includes a central passageway **96** for communication between the first end **92** and second end **98**. Second end **98** includes outwardly flared edge **99**. Immediately inwardly adjacent from second end **98**, annular notch **100** is formed. As shown in the cut-away views of FIGS. 2A and 2B, annular notch **100** has a ramped portion **102**, an interior flat portion **104** and a transverse annular wall section **106** to correspond or to be complementary to the ramped portion **25**, flat distal portion **27** and transverse orthogonal wall **29** of first and second latching bosses **26, 28** of housing **10**. Additionally, as shown in FIGS. 2A and 2B, an annular ridge **108** is formed interiorly adjacent from annular notch **100** in order to form a seat for the cap **88** of cartridge **82**. Similarly, annular lip **110** is formed on the interior of cylindrical wall **94**, immediately inwardly adjacent from first end **92** to snap engage the cap **88** of cartridge **82**.

As shown in FIGS. 5 and 6, the cartridge-to-housing interface **90** (which has been bulk sterilized by gamma ray, ultra-violet or a similar method as appropriate to the design) and cartridge **82** are brought into a controlled area (laminar airflow ISO class air supply). During bulk sterilization, the cartridges **82** are oriented vertically with the cap **88** on top and have their top surface sterilized with pulsed ultra-violet light or by a similar method. The cartridge-to-housing interface **90** is then pressed onto the cap **88** as shown in FIGS. 5 and 6 whereby the interior of cylindrical wall **94** of the first end **92** of the cartridge-to-housing interface **90**

forms a friction fit with the cap **88** of cartridge **82** thereby forming second sterile barrier **170**, extending circumferentially around the cap **88** as it contacts the interior of cylindrical wall **94** (see FIGS. 2A and 2B) of the cartridge-to-housing interface **90** providing a maximum insertion, and a seat for the cartridge **82** while annular lip **110** of the cartridge-to-housing interface **90** snap engages the cap **88** of cartridge **82**. This results in second subassembly **118**.

As shown in FIGS. 7A, 7B, and 7C, the cartridge subassembly **118**, comprising the cartridge **82** with the cap **88** engaged by the cartridge-to-housing interface **90**, is inserted into the initial subassembly **80** through the rear opening **17** of housing **10** thereby achieving the configuration of the injector subassembly **119** of FIGS. 7B and 7C. In the configuration of FIG. 7C, and as shown in detail in FIG. 2A, the first and second latching bosses **26**, **28** of first and second cantilevered locking tabs **18**, **20**, which are prevented from outward deflection by the needle sheath **70**, provide a stop for the maximum insertion of the cartridge-to-housing interface **90** in this pre-armed configuration. Further, this maximum insertion of the cartridge-to-housing interface **90** provides for the butt end **44** of needle cannula **40** to be separated from the cap **88** and septum **89** of cartridge **82**. Additionally, as shown in FIGS. 2A and 2B, third sterile barrier **172** is formed circumferentially around the cartridge-to-housing interface **90** as it the inner diameter of the housing **10**.

FIGS. 8 and 9 are illustrations of plunger rod assembly **120** which includes plunger rod **130** and harpoon **160**. The plunger rod **130** is made from hard polyethylene or polypropylene, but are not limited thereto while the harpoon **160** is made from stainless steel or a similar material, but is not limited thereto. Plunger rod **130** includes circular thumb ring **132** and shaft **134**. Shaft **134** includes proximal end **136** attached to circular thumb ring **132** and distal end **138** which includes annular retention channel **117** between annular ring **117A** and distal annular terminating ridge **117B**. Harpoon **160** extends from longitudinal blind bore **142** and, as shown in FIG. 10C, is separated from the cartridge plunger **86** when injection device is in the pre-armed configuration, but engages the cartridge plunger **86** when the injection device **200** is in the armed state and when the injection is being administered. The assembly of the harpoon **160** into the shaft **134** can be done in many different ways. For example, as depicted in FIGS. 8 and 9 the harpoon **160** may be press fit into a terminal end of the shaft **134**. In another example depicted in FIG. 16, the harpoon **160** is insert molded as part of molding the shaft **134**.

The plunger rod assembly **120** of FIGS. 8 and 9 is engaged within the mounting hub **12A** as illustrated in the areas A-A and B-B of cross-sectional detail of FIG. 1A. An internal annular retention ring **95** is formed on the interior of passageway **63** for engaging with a corresponding external annular retention channel (see element **118**, FIG. 8A) on the plunger rod assembly **120**. The internal annular retention ring **95** has a cross section with a sloped surface **95A** facing toward the proximal end or user end, in order to facilitate insertion of the plunger rod assembly **120**, but with an abrupt orthogonal surface **95B** toward the distal end in order to capture the plunger rod assembly **120** once it is inserted, and to resist any subsequent withdrawal of the plunger rod assembly **120**. The annular retention channel **117** is formed on shaft **134** of plunger rod assembly **120** between annular ring **117A** and distal annular terminating ridge **117B**. When the shaft **134** of plunger rod assembly **120** is initially inserted into passageway **63**, the distal end of plunger rod assembly **120** slides over the sloped surface **95A** of internal annular retention ring **95** so that internal annular retention

ring **95** is captured within annular retention channel **117** between annular ring **117A** and distal annular terminating ridge **117B**. Similarly, the relationship or contact between the opposing orthogonal surfaces of distal annular terminating ridge **117B** and orthogonal surface **95B** resists any subsequent withdrawal of the plunger rod assembly **120** from the passageway **63**. Likewise, the relationship or contact between the sloped surface **95A** of internal annular retention ring **95** and the annular ring **117A** causes a snap detent engagement of the plunger rod assembly **120** which holds the plunger rod assembly **120** in place, but which allows the medical professional to press against the plunger rod assembly **120** to overcome the snap detent engagement, thereby often causing both audible and tactile feedback, with the plunger rod assembly **120** being driven into passageway **63**.

As shown in FIGS. 10A, 10B and 10C, the plunger rod assembly **120** is inserted into injector subassembly **119**. In this inserted configuration of FIG. 10C, the configuration shown in the cross-sectional area of FIG. 1A is achieved. This configuration of the external annular channel **117** and the internal annular retention ring **95** often provides a tactile snap, as well as audible feedback, for the user while pushing the plunger rod assembly **120** to operate the injection device **200**. FIG. 15 illustrates that as force or energy is applied, the snap detent configuration of internal annular retention ring **95** and external annular channel **117** holds the energy until approximately fifteen pounds-force is applied as shown on the Y-axis, whereas the X-axis is sample number, at a sampling rate of 24,000 samples per second. Then, disengagement of the detent configuration occurs, the momentum is momentarily released to allow the harpoon **160** to travel at a faster speed and force than would occur without the snap detent configuration. This is particularly a benefit for users who are not as likely to use an aggressive slap style of activation.

FIGS. 10B and 10C illustrate the injection device **200** in the pre-armed state as it is often provided to the customer in a flow wrapper package (not shown). In this pre-armed state, as shown in FIGS. 2A and 10C, the butt end **44** of needle cannula **40** is separated from the cap **88** and septum **89** of cartridge **82** and the harpoon **160** is separated from the cartridge plunger **86**. In particular, as shown in FIG. 2A, this separation of the butt end **44** of the needle cannula **40** from the septum **89** of cartridge **82** is caused by the rigid positioning of first and second latching bosses **26**, **28** of first and second cantilevered locking tabs **18**, **20**, as constrained by the needle sheath **18**, providing a stop to the forward movement of the cartridge subassembly **118** comprising the cartridge-to-housing interface **90** and cartridge **82**.

FIGS. 17, 18 and 19 illustrate an alternative embodiment of the injection device **200** of the present disclosure, wherein the housing **12** does not include the mounting hub **12A**.

The embodiment of FIGS. 17, 18 and 19 includes some different elements from the other embodiment. For instance, the finger flange assembly **60** includes first and second notches **65**, **67** and further includes central bore **66** which with an internal annular snap ring **69** which is snap engaged between the first and second external snap ridges **153**, **155** of the plunger cap **150**. This forms a sandwiched engagement between the rear annular rim **16** of housing **10** between the finger flange assembly **60** and the plunger cap **150**. This sandwiched engagement is sufficiently tight to ensure structural stability but retains the ability of the finger flange assembly **60** to rotate with respect to the housing **10**. Furthermore, a snap detent engagement is formed between

an annular snap ring ridge **140** on the shaft **134** of plunger rod **130** and an annular snap notch of the plunger cap **150**.

In order to arm the injection device **200** for an injection, the user removes the injection device **200** from the flow wrapper package. The user then removes the needle sheath **70** from the housing **10** of injection device **200**. The removal of needle sheath **70** from the housing **10** removes the constraint on the outward flexure of first and second cantilevered locking tabs **18, 20**. The user then manually engages the finger flanges **62, 64** and the circular thumb ring **132** in the conventional manner and depresses the circular thumb ring **132**. This releases, overcomes, or disengages the detent or snap-fit engagement between the annular retention channel shaft **134** of the plunger rod assembly and the annular retention ring **95** of mounting hub **12A** (often producing audible feedback) and drives the harpoon **160** into engagement with the cartridge plunger **86** of cartridge **82**. Further movement of the plunger rod **30** urges the cartridge **82** and the cartridge-to-housing interface **90** (i.e., the cartridge subassembly **118**) forward. It is noted that while the cartridge **82** is sealed with the cap **88** intact, the cartridge plunger **86** cannot move within the cylindrical wall **84** of cartridge **82** and insertion of the plunger rod **30** is translated into forward movement of the cartridge **82** and the cartridge-to-housing interface **90** toward the distal end **204**. This forward movement further causes the outward flexure of the first and second cantilevered locking tabs **18, 20** as the second end **98** of cartridge-to-housing interface **90** is urged against the ramped portions **25** of first and second latching bosses **26, 28** of first and second cantilevered locking tabs **18, 20**. As second end **98** of cartridge-to-housing interface **90** passes over the first and second latching bosses **26, 28** and abuts against an interior of the frustoconical section **30**, the first and second cantilevered locking tabs **18, 20** snap back into place whereby first and second latching bosses **26, 28** are engaged within annular notch **100** of cartridge-to-housing interface **90**. Further, outwardly flared edge **99** of second end **98** of cartridge-to-housing interface **90** is engaged between the interior of the frustoconical section **30** and the transverse orthogonal wall **29** of first and second latching bosses **26, 28**. Additionally, this forward movement of the cartridge **82** causes the butt end **44** of cannula **40** to pierce the septum **89** of cartridge **82** thereby providing a sterile fluid pathway between the cartridge **82** and the cannula **40**. Often, audible feedback is generated when the injection device **200** goes from the first engagement or pre-armed position (FIG. 1A) to the second engagement or armed position (FIG. 1B). The audible feedback provides the medical professional with an indication that the needle or cannula **40** is engaged to fully connect the fluid pathway. With the position of the cartridge **82** stabilized by the engagement between the first and second cantilevered latching tabs **18, 20** and the cartridge-to-housing interface **90**, and with the septum **89** pierced, further depression or insertion of the plunger rod **130** drives the cartridge plunger **86** further into the cartridge **82** thereby causing the ejection of the injectable agent out of the cartridge **82** through the central passageway **46** of cannula **40** for injection into a patient.

FIG. 14 illustrates an exemplary assembly or manufacturing method for injection device **200**, but the assembly or manufacture of injection device **200** is not limited thereto. The order of steps presented is merely illustrative and may be performed in a different order or in parallel operations.

In step **602**, which is performed in an aseptic environment at least with respect to the needle **40** and any elements which form the sterile fluid pathway, the cannula crimp insert **50**, with the needle **40** inserted therein, is inserted into the

forward nose **14** of housing **10**. Additionally, the needle sheath **70** is mounted on the housing **10** and the finger flange assembly **60** is positioned on the mounting hub **34** of housing **10** thereby resulting in the initial subassembly **80** of FIGS. 3 and 4. In step **604**, which is performed in an aseptic environment at least with respect to the septum **89** and the cartridge-to housing interface **90** to the extent that they form the sterile fluid pathway, the cartridge **82** is inserted into the cartridge-to-housing interface **90** thereby resulting in the cartridge subassembly **118** of FIGS. 5 and 6. In step **606**, which is performed in an aseptic environment, the cartridge subassembly **118** of FIGS. 5 and 6 is inserted into the initial subassembly **80** of FIGS. 3 and 4 thereby resulting in the injector subassembly **119** of FIGS. 7A, 7B and 7C. In step **608**, which is not necessarily performed in an aseptic environment, the plunger rod assembly **120** is attached to the injector subassembly **119** as shown in FIGS. 10A, 10B and 10C thereby resulting in the pre-armed injection device **200** of FIG. 10C as well as FIG. 1A. In step **610**, the resulting injection device **200** may be packaged, which is not necessarily performed in an aseptic environment.

Thus the several aforementioned objects and advantages are most effectively attained. Although preferred embodiments of the invention have been disclosed and described in detail herein, it should be understood that this invention is in no sense limited thereby and its scope is to be determined by that of the appended claims.

What is claimed is:

1. An injection device comprising:

a cartridge with a first cartridge end and a second cartridge end, the first cartridge end being closed and the second end including a cartridge plunger, the first cartridge end including a septum and a cap securing the septum to the first cartridge end;

a housing enclosing the cartridge, the housing including a first housing end and a second housing end, the housing including at least one movable cartridge stop;

a needle including a cannula, the needle being engaged to the first end of the housing; and

a cartridge adapter separately formed from the cap and the cartridge and having a first adapter end and a second adapter end, the first adapter end receiving and engaging the cap at the first cartridge end, the adapter further including an annular element slidably engageable within the movable cartridge stop, wherein the adapter is movable between a first position and a second position with respect to the at least one movable cartridge stop, wherein the annular element is disposed distally of the cartridge.

2. The injection device of claim 1 wherein in the first position, the cannula is spaced away from the first cartridge end and wherein in the second position, the cannula penetrates the first cartridge end thereby providing communication of contents of the cartridge to the cannula.

3. The injection device of claim 2 wherein in the first position, the cartridge adapter abuts the at least one movable cartridge stop thereby maintaining a position of the cartridge and maintaining separation between the cannula and the first cartridge end, and wherein in the second position, the annular element is in detent engagement with the movable cartridge stop.

4. The injection device of claim 3 wherein in the first position, the annular element is free of engagement with the at least one movable cartridge stop.

5. The injection device of claim 3 wherein annular element is an annular notch disposed distal of the cap.

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6. The injection device of claim 5 wherein the at least one movable cartridge stop includes at least one cantilevered tab.

7. The injection device of claim 6 wherein the housing further includes at least one wall and the at least one cantilevered tab is formed from the at least one wall.

8. The injection device of claim 7 wherein the at least one wall is a cylindrical wall.

9. The injection device of claim 7 further including a sheath covering the needle, the sheath including a first sheath end and a second sheath end, wherein the first sheath end is open and is engageable with the housing so as to prevent outward movement of the at least one cantilevered tab.

10. The injection device of claim 9 wherein when the sheath engages the housing, the cartridge adapter is prevented from moving from the first position to the second position and wherein when the sheath is removed from sheath, the at least one cantilevered tab can flex outward thereby allowing the cartridge adapter to move from the first position to the second position.

11. The injection device of claim 10 further including a plunger rod assembly extending through the second housing end, for engagement with the cartridge plunger.

12. The injection device of claim 11 wherein when the sheath is removed from the housing, movement of the plunger rod assembly can move the cartridge adapter from the first position to the second position.

13. The injection device of claim 12 wherein the plunger rod assembly includes a plunger detent element for engaging the second housing end, thereby holding the plunger rod assembly in place prior to engagement with the cartridge plunger.

14. The injection device of claim 13 wherein the plunger detent element provides a snap detent engagement between the plunger rod and the second housing end, whereby user operation of the plunger rod builds up force prior to release of the snap detent engagement thereby increasing a velocity of the plunger rod.

15. The injection device of claim 13 wherein disengagement of the plunger detent element produces tactile feedback.

16. The injection device of claim 12 further including a radially extending finger flange assembly proximate to the second housing end.

17. The injection device of claim 12 wherein the finger flange assembly is rotatable with respect to the housing.

18. The injection device of claim 1 wherein the cap is made of metal.

19. The injection device of claim 18 wherein the cartridge includes a drug or pharmaceutical product.

20. The injection device of claim 1 wherein an inner surface of the cartridge adapter engages an outer surface of the cap.

21. The injection device of claim 1 wherein the cartridge adapter extends distally from the cap.

22. A method of assembly of an injection device, including the steps of:

providing a housing including a first housing end, a second housing end, at least one wall and at least one housing stop element;

providing a needle including a needle cannula; engaging the needle within the housing;

providing a needle sheath with a first sheath end and a second sheath end, wherein the first sheath end is open;

engaging the needle sheath to the housing thereby covering at least a part of the cannula and restraining movement of the at least one housing stop element;

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providing a finger flange assembly;

attaching the finger flange assembly proximate to the second housing end;

providing an adapter including an annular element;

providing a cartridge including a first cartridge end which is closed and a second cartridge end which includes a cartridge plunger, the first cartridge end including a septum and a cap securing the septum to the first cartridge end;

attaching the first cartridge end of the cartridge to the adapter such that the adapter receives and engages the cap of the cartridge, the adapter being separately formed from the cap and the cartridge;

inserting the cartridge and the adapter into the second housing end whereby the cartridge is in a first position with respect to the at least one housing stop element, wherein the annular element is disposed distally of the cartridge and slidably engageable within the at least one housing stop element;

providing a plunger rod including a shaft and an element for engagement with the cartridge plunger; and

inserting the shaft into the second housing end; whereby subsequent removal of the needle sheath allows movement of the at least one housing stop element and allows the adapter to move to a second position with respect to the at least one housing stop element.

23. The method of claim 22 wherein in the first position of the adapter with respect to the at least one housing stop element, the needle cannula is separated from the first cartridge end, and wherein the second position of the adapter with respect to the at least one housing stop element, the needle cannula punctures the first cartridge end.

24. The method of claim 23 further including the step of sterilizing the first cartridge end prior to the step of attaching the first cartridge end of the cartridge to the adapter.

25. The method of claim 24 wherein the step of sterilizing the first cartridge end is performed by pulsed ultra-violet light.

26. The method of claim 25 further including the step of sterilizing at least a portion of the adapter prior to the step of attaching the first cartridge end of the cartridge to the adapter.

27. The method of claim 26 wherein the step of sterilizing at least a portion of the adapter is performed by bulk gamma ray or ultra-violet sterilization.

28. The method of claim 22 wherein the cartridge contains a drug or pharmaceutical product.

29. An injection device comprising:

a cartridge with a first cartridge end and a second cartridge end, the first cartridge end being closed and the second end including a cartridge plunger, the first cartridge end including a cap;

a housing enclosing the cartridge, the housing including a first housing end and a second housing end, the housing including at least one movable cartridge stop;

a needle including a cannula, the needle being engaged to the first end of the housing; and

a cartridge adapter with a first adapter end and a second adapter end, an inner surface of the cartridge adapter at the first adapter end engaging an outer surface of the cap, the adapter further including an annular element slidably engageable within the movable cartridge stop, wherein the adapter is movable between a first position and a second position with respect to the at least one movable cartridge stop, wherein the annular element is disposed distally of the cartridge; and

a plunger rod assembly extending through the second housing end, for engagement with the cartridge plunger.

30. The injection device of claim 29 further including a sheath covering the needle, the sheath including a first sheath end and a second sheath end, wherein the first sheath end is open and is engageable with the housing so as to prevent outward movement of the at least one movable cartridge stop.

31. The injection device of claim 30 wherein when the sheath engages the housing, the cartridge adapter is prevented from moving from the first position to the second position and wherein when the sheath is removed from sheath, the at least one movable cartridge stop can flex outward thereby allowing the cartridge adapter to move from the first position to the second position.

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